

Work Order ID 67995

Tuesday, April 05, 2011 10:45:40 AM

Page 1

Item ID: D4380-17

Accept

Revision ID: PRELIM

Item Name: Panel, RH Becker Audio

Start Date: 4/5/2011 Start Qty: 1.00

Required Date: 4/5/2011 Req'd Qty: 1.00

Reference:

Cust Item ID:

Customer:

PRELIMINARY ISSUE

Approvals: Process Plan: MF Date: 11-04-05

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D4380

PAG PAZ. 11/04/05 ADK

100

0.00

HandThermo

Memo

0.00

Hand Finishing Thermoforming

1-Cut Sheet to required Blank size

105

0.00

HandThermo

Dry Material

Memo

0.00

Hand Finishing Thermoforming

Dry Sheet as per QSI022 Kydex

Temp: 150° F

Time IN: 6:00 pm. 11/04/04

Time OUT: 7:00 am 11/04/05

B
11/04/05

B
11/04/05

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Setup Start

Stop

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Required Date: 4/5/2011 Req'd Qty: 1.00

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Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

Stop

QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

110

0.00



Thermoform

Memo

0.00

Thermoforming Machine

1-Machine Set-Up
2-Pre-heat Tool to required temp.
3-Thermoform as per Dwg and Folio #FTA118 using tool DT9743

Dwg Rev: 19A-7Folio Rev: 4

1

11/04/05

120

0.00



QC

Quality Control

QC2- Inspect parts off machine FAI/FAIB

Memo

0.00

Visually inspect part for proper formation and texture

1

11/04/05

130

0.00



QC

Quality Control

QC8- Inspect parts - second check

Memo

0.00

11/04/05

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Item ID:	D4380-17	Accept		Setup	Start	
Revision ID:	PRELIM				Stop	
Item Name:	Panel, RH Becker Audio					
Start Date:	4/5/2011	Start Qty:	1.00		Cust Item ID:	
Required Date:	4/5/2011	Req'd Qty:	1.00		Customer:	
Reference:						

Approvals:	Process Plan:	Date:	Tooling:	Date:	Run	Start	
	QC:	Date:	SPC (Y/N):	Date:		Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
140 	HandThermo	0.00							
	Memo	0.00							
Hand Finishing Thermoforming	1-Trim to finished dimensions as per Dwg								<i>Dh.</i> <i>11/04/05</i>
150 	QC2- Inspect parts off machine FAI/FAIB	0.00							
	Memo	0.00							
QC	Complete FAI document								<i>Dh.</i> <i>11/04/05</i>
Quality Control									
160 	QC5- Inspect part completeness to step on W/O	0.00							
	Memo	0.00							
QC									
Quality Control									<i>- inspect for PA →</i> <i>Don only</i> <i>Swley/06</i> <i>(40)</i>

W/O:		WORK ORDER CHANGES					
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Item ID: D4380-17

Accept



Setup Start



Revision ID: PRELIM

Stop



Item Name: Panel, RH Becker Audio

Start Date: 4/5/2011 Start Qty: 1.00



Cust Item ID:

Required Date: 4/5/2011 Req'd Qty: 1.00



Customer:

Reference:

Run Start



Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

170

Identify as per dwg & Stock Location: EAGLE

0.00



Packaging

Memo

0.00

Packaging

11/4/10

180

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/5/10

RD
2370

POSITIVE RECALL

EFFECTIVE 11/04/10

RELEASED MP

AUTH U

DATE 11/04/10

MF 11-04-10
06

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Picklist Print

Tuesday, April 05, 2011 10:45:37 AM

Page 1

Work Order ID: 67995

Parent Item: D4380-17

Parent Item Name: Panel, RH Becker Audio


Start Date: 4/5/2011

Required Date: 4/5/2011

Start Qty: 1.00

Required Qty: 1.00

Comments: Rev. A New Issue. 11/04/04 DL verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MKYD6185S.080-P3- 62015		Purchased		No		100	sf	787.2912	3.46875	3.46875			
													
6185 KYDEX .080"													

Location

Loc Qty

Loc Code

therm

787.2912

116576

787.2912

3.46875 sf 4

Ala
11/04/06

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DART AEROSPACE LTD	Work Order: 67995
Description: 24 Becker Audio Panel	Part Number: 04380-17
Inspection Dwg: 04380 Rev: PA7	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST
THERMOFORMING SECTION

Description	Accept	Reject	Method of Inspection	Comments
Inside Radii less than <u>1/4</u> "	✓			
Shape Definition	✓			
Texture Retention	✓			
Material imperfections such as bumps, cracks, voids, scratching	✓			

Measured by: Dh.

Date: 11/04/05

TRIMMING SECTION

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
7.8"		7.8"	✓		Tape DL01	
5.8"		5.8"	✓		Tape DL01	
6.5"		6.5"	✓		Tape DL01	
4.5"		4.5"	✓		Tape DL01	
1.4"		1.375"	✓		Tape DL02	
2.1"		2.0"	✓		Tape DL01	
2.0"		2.019"	✓		Ureter DL02	

Measured by: Dh.

Date: 11/04/05

Audited by: S PA7 Dwg only

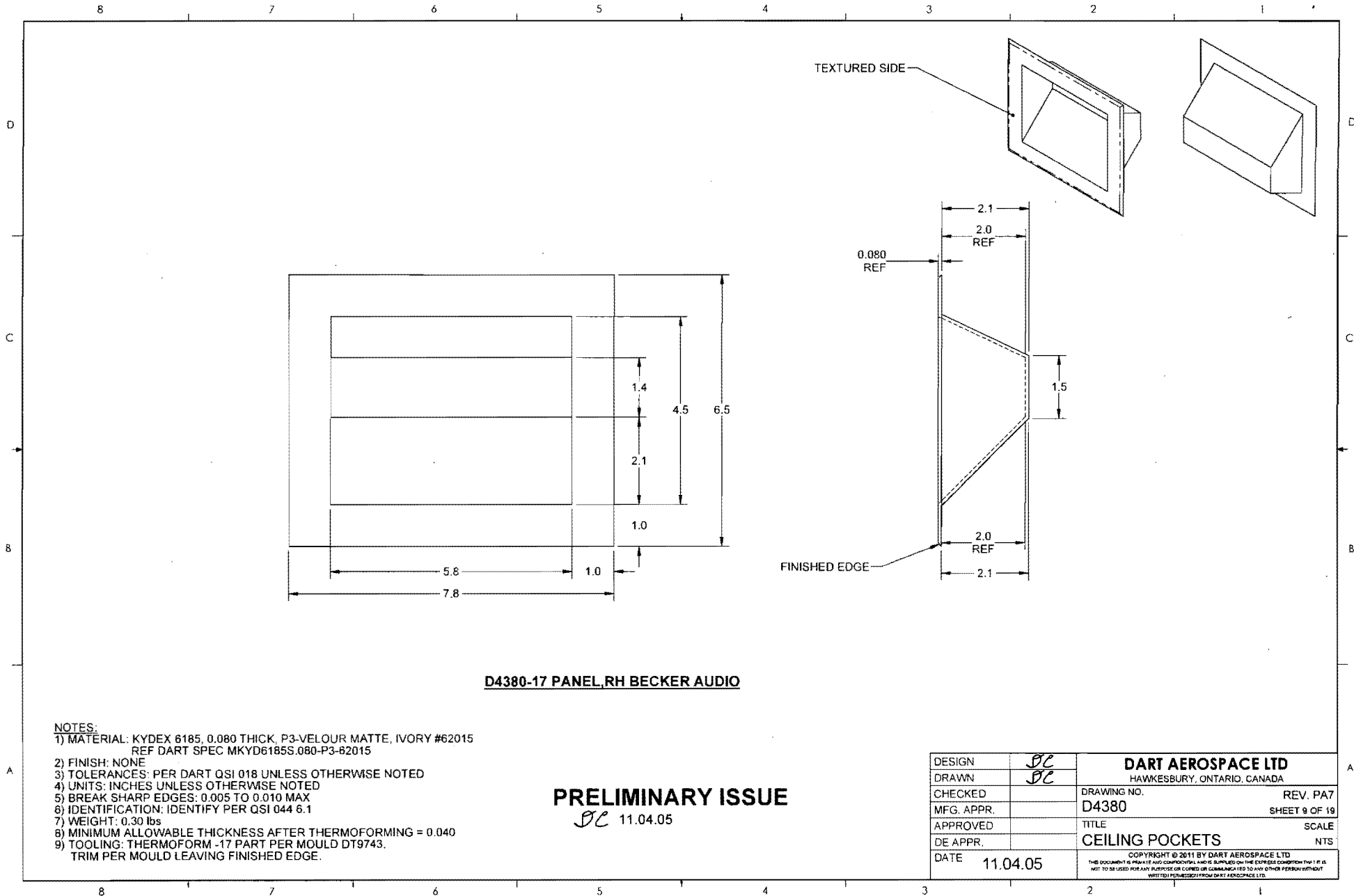
Date: 11/04/06

Preliminary Approval: _____

Date: _____

Rev	Date	Change	Revised by	Approved
B	10.04.14	Added preliminary approval	KJ	

10.04.14



D4380-17 PANEL, RH BECKER AUDIO

NOTES:

- 1) MATERIAL: KYDEX 6185, 0.080 THICK, P3-VELOUR MATTE, IVORY #62015
REF DART SPEC MKYD6185S.080-P3-62015
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1
- 7) WEIGHT: 0.30 lbs
- 8) MINIMUM ALLOWABLE THICKNESS AFTER THERMOFORMING = 0.040
- 9) TOOLING: THERMOFORM -17 PART PER MOULD DT9743.
TRIM PER MOULD LEAVING FINISHED EDGE.

PRELIMINARY ISSUE

DL 11.04.05

DESIGN	DL	DART AEROSPACE LTD	
DRAWN	DL	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. PA7
MFG. APPR.		D4380	SHEET 9 OF 19
APPROVED		TITLE	SCALE
DE APPR.		CEILING POCKETS	NTS
DATE	11.04.05	COPYRIGHT © 2011 BY DART AEROSPACE LTD	
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Daryl Leger

From: Daniel Campbell <dcampbell@dartaero.com>
Sent: Monday, April 04, 2011 9:16 AM
To: 'Daryl Leger'
Cc: 'JEANLUC MENARD'; Bill Beckett; 'Linda Lacelle'; 'Harvey Siemens'; 'Mike Petsche'
Subject: D4323 & D4380 - Parts can be untrimmed

To Whom It May Concern,

The parts with p/n's D4323-XX and D4380-XX can be shipped to Calgary untrimmed, or even slightly out of spec in order to get parts here asap so they can be installed on the Westpac machine.

Thanks,

Daniel Campbell
Mechanical Engineer
DART Aerospace Ltd.

P: 403-717-0325
F: 403-717-1288
E: dcampbell@dartaero.com
W: www.dartaero.com
M: 1060 McTavish Road, NE, Calgary, Alberta, T2E 7G6

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